

S.FAB



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10126
8614 16731
9817
7077

RBWA353A04

Job Sheet 183340

Part No: RBWA353A04

Job Qty: 1 ea

Part Name: Pmc Oil Filling Quick Disconnect



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/16/18

Job Tracking No:

Due Date: 10/1/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBWA353A04 Rev 4 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/1/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs		10/1/18	0.00	1.00	Small Fab-3		MLC
120	QC	1 pcs		10/1/18	0.00	0.00	QC5		MLC
130	Packaging	1 pcs		10/1/18	0.00	0.00	Packaging3-1		MLC
140	QC21-SA	1 Ea		10/1/18	0.00	0.00	QC21		MLC

Part Op 110 - 1-Assemble as per DWG. Sheet . 2-Engrave 1632T22 tag using marktronic engraver as per DWG. 3-Fabricate and
Descriptions: attach lanyard as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1632T22	Aluminum Tag 1" X 2" X 0.04"	1 pcs (1 ea)	90-Start up Operation	5118665
2619	Spring Rnd 3/4" (Century Spring)	1 Ea (1 ea)	90-Start up Operation	5075045
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	90-Start up Operation	5084066
50715K179	Female Pipe Adapter SS	1 Ea (1 ea)	90-Start up Operation	5048068
91665A350	Retaining Ring, 7/16" Shaft	1 Ea (1 ea)	90-Start up Operation	5046064
9262K613	O-Ring 13mm OD x 1mm	1 Ea (1 ea)	90-Start up Operation	5046049
CL-2-C	Lanyard Wire	.4200 ft (.42 ea)	90-Start up Operation	5093863
RBWA353A04-01	Cap	1 Ea (1 ea)	90-Start up Operation	5061607
RBWA353A04-02	Sleeve	1 Ea (1 ea)	90-Start up Operation	5059120
RBWA353A04-03	Barb	1 Ea (1 ea)	90-Start up Operation	5061009
RBWA353A04-05	Quill	1 Ea (1 ea)	90-Start up Operation	5130861
RBWA353A04-06	Cap	1 Ea (1 ea)	90-Start up Operation	5061857
RBWA353A04-07	Valve	1 Ea (1 ea)	90-Start up Operation	5137129
RBWA353A04-08	Screw (Modified B/O)	2 Ea (2 ea)	90-Start up Operation	5057743
S1030	Spring .025 Wire: .300 O.D X .5 free length	1 Ea (1 ea)	90-Start up Operation	5107889



Container No: S139954



Part: RBWA353A04

Job No: 183340

Serial No/Batch: S139954

Revision: 4

Inspector:

Exp Date:

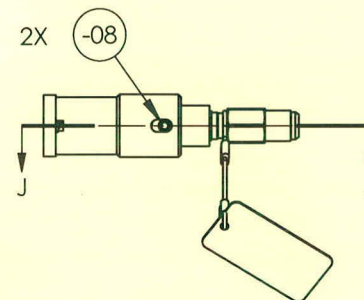
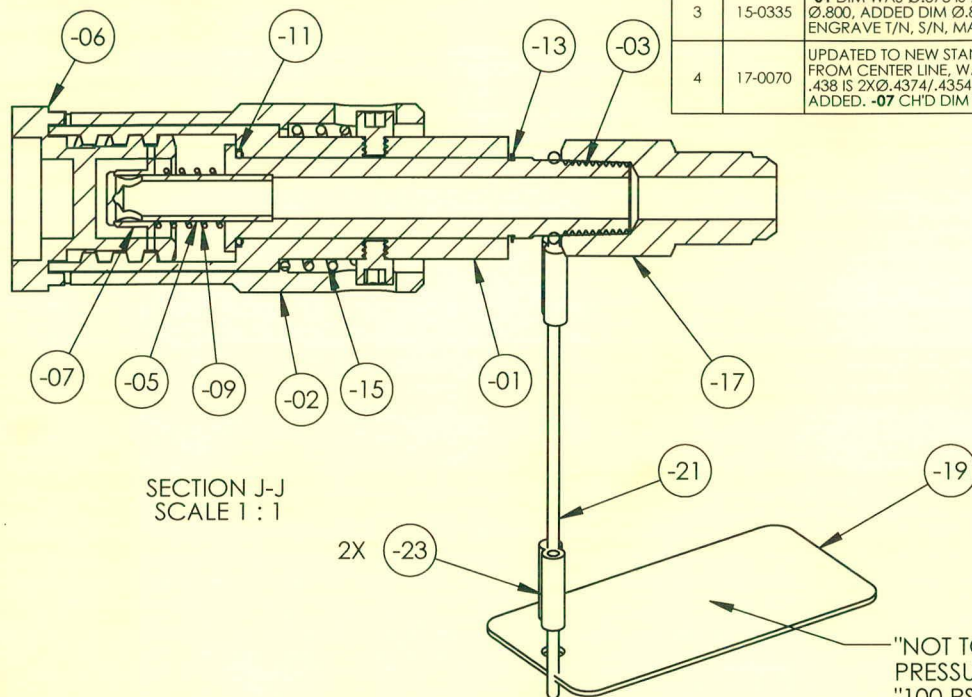
Instructions:

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED ASSEMBLY	2/22/2011	JAG	
2		DELETED -19, -21, & -23 CH'D -15 FROM HOSE & -17 FROM HOSE CLAMP. ADDED -19, -21, & -23. -01 CH'D TO CLEAR ANODIZE. -02 CH'D TO CLEAR ANODIZE. CH'D -03 THRU HOLE FROM Ø.17. CH'D DESIGN ADDED 1/8 NPT -27 FOR FITTING. CH'D -05 ID FROM Ø.14 & CH'D LIMIT DIMENSION FROM Ø.2510-.2514 S.F. -07. CH'D -07 ID LIMIT DIM. FROM Ø.2515-.2520 & S.F. -05 PER D.W.	1/17/2012	RJC	DW
2A		-03 REMOVED X.50 DEPTH FROM 1/8 NPT	1/3/2013	BIM	GE
3	15-0335	-01 DIM WAS Ø.675 IS Ø.665 TO ACCOMODATE NEW -15 SPRING. -02 CH'D DIM WAS 2X Ø.800 IS Ø.800. ADDED DIM Ø.810 FOR NEW SPRING. CH'D ENGRAVE NOTE WAS ENGRAVE T/N TO FIT IS ENGRAVE T/N, S/N, MADE IN USA. -15 CH'D P/N WAS CENTURY SPRING #B15-66 IS 2619.	10/13/2015	RJC	JAG
4	17-0070	UPDATED TO NEW STANDARDS. -01 CH'D FLANK OF THREAD START WAS ON CENTERLINE, IS 5° OFFSET FROM CENTER LINE, WAS 17° IS (16°); WAS (.10) IS (.08); WAS .101 IS .100. -03 CH'D DIM WAS 2X Ø.438 IS 2X Ø.4374/.4354. -05 CH'D DIM WAS Ø.2515/.2510 S.F. -07 IS Ø.2515/.2510 (S.F. -07). -06 ADDED. -07 CH'D DIM WAS Ø.2530/.2520 S.F. -05 IS Ø.2530/.2520 (S.F. -05).	3/21/2017	SM	JAG



B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	-01	1	CAP	6061		2
	-02	1	SLEEVE	6061		3
	-03	1	BARB	303/304 S.S.		4
	-05	1	QUILL	303/304 S.S.		5
	-06	1	CAP	6061		6
	-07	1	VALVE	303/304 S.S.		7
	-08	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	8
B/O	-09	1	SPRING	MUSIC WIRE	Ø.025 WIRE: Ø.300 OD X .5 FREE LENGTH (RIED #S1030)	1
B/O	-11	1	O-RING	BURNA-N	Ø13mm OD X 1mm (MCMaster-CARR #9262K613)	1
B/O	-13	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT (MCMaster-CARR #91665A350)	1
B/O	-15	1	SPRING	SPRING STEEL	Ø.78 (CENTURY SPRING #2619)	1
B/O	-17	1	FEMALE PIPE ADAPTER	S.S.	MCMaster-CARR #50715K179	1
	-19	1	TAG	ALUMINUM	1/32 X 1 X 2	1
B/O	-21	1	LANYARD	COATED GALV. STEEL	(7X7 CABLE) Ø1/16 X 5in. (CARR LANE #CL-2-2)	1
B/O	-23	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	1

		TITLE	
		PMC OIL FILLING QUICK DISCONNECT	
DWG NO.		RBWA353A04	
REV		4	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		.X ± .1 SURFACES = 125/	
CHECKED:		1. BREAK ALL SHARP EDGES	
OPPS APPR:		.015 x 45° OR .015R	
QA APPR:		2. DIMENSIONAL LIMITS APPLY	
APPROVED:		AFTER PLATING	
SCALE		3. INTERPRET DIM AND TOL PER	
1:3		ASME Y14.5M-2009	
DATE		USED ON MODEL	
2/22/2011		AGUSTA HELICOPTERS	
SHEET 1 OF 8			

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	1632T22	1	46	0
	2619	1	47	0
	3896T31	2	1,033	0
	50715K179	1	2	0
	91665A350	1	30	0
	9262K613	1	90	0
	CL-2-C	0	348	0
	RBWA353A04-01	1	6	0
	RBWA353A04-02	1	3	0
	RBWA353A04-03	1	1	0
	RBWA353A04-05	1	0	0
	RBWA353A04-06	1	6	0
	RBWA353A04-07	1	0	0
	RBWA353A04-08	2	26	0
	S1030	1	10	0
Part Specifications				
Specifications could not be found.				

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE**DART**
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS				
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		FAULT CATEGORY Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____								